



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3490-5

Job Sheet 195251



Part No: D3490-5

Job Qty: 100 pcs

Part Name: Cross Bolt Spacer



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/16/19

Job Tracking No:

Due Date: 9/6/19

Created By: Kimberley Guerin

Type: Stock

Description:

Note: DWG REV A IPP Rev:A New Issue 06-03-03 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Run Hrs Hrs	Workcenter/Supplier	Sign-off
130	Purchasing	100 pcs	9/6/19	9/6/19	0.00 0.00	Purchasing - 1	
						Purchasing - 2	
						Purchasing - 3	
140	Packaging 2-1 - Receive - B4B	100 pcs	9/6/19	9/6/19	0.00 0.00	Packaging 2 - 1 - B4B	
						Packaging 2 - 2 - B4B	
						Packaging 2 - 3 - B4B	
						Packaging 2 - 5 - B4B	
						Packaging 2 - 4 - B4B	
						Packaging 2 - 6 - B4B	
						Packaging 2 - 7 - B4B	
						Packaging 2 - 8 - B4B	
						Packaging 2 - 9 - B4B	
						Packaging 2 - 10 - B4B	
						Packaging 2 - 11 - B4B	
						Packaging 2 - 12 - B4B	
						Packaging 2 - 13 - B4B	
						Packaging 2 - 14 - B4B	
						Packaging 2 - 15 - B4B	
						Packaging 2 - 16 - B4B	
						Packaging 2 - 17 - B4B	
						Packaging 2 - 18 - B4B	
						Packaging 2 - 19 - B4B	
						Packaging 2 - 20 - B4B	
						Packaging 2 - 21 - B4B	
						Packaging 2 - 22 - B4B	
						Packaging 2 - 23 - B4B	
						Packaging 2 - 24 - B4B	
						Packaging 2 - 25 - B4B	
						Packaging 2 - 26 - B4B	
						Packaging 2 - 27 - B4B	
						Packaging 2 - 28 - B4B	



Container No: S210483



Part: D3490-5

Job No: 195251

Serial No/Batch: S210483

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/30/19

Plex 5/16/19 10:36 AM Dart.Guerin.Kimberley

5/16/2019

[Dart Hawkesbury] Job Sheet - Guerin, Kimberley

					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
150 QC 6	100 pcs	9/6/19	0.00 0.00		QC 6 - 9	
					QC 6 - 68	DAS
					QC 6 - 61	61
					QC 6 - 40	9-89
160 Packaging 3-1 - Stock - B4B	100 pcs	9/6/19	0.00 0.00	Packaging 3 - 1 - B4B		
				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 - B4B		
				Packaging 3 - 22 - B4B		
				Packaging 3 - 23 - B4B		
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		10
				Packaging 3 - 27 - B4B		
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B		
				Packaging 3 - 35 - B4B		
				Packaging 3 - 36 - B4B		
170 QC 21 - SA	100 pcs	9/6/19	0.00 0.00	QC 21 - SA - 21		
				QC 21 - SA - 70		DAS
				QC 21 - SA - 53		21
Part Op 130 - ISSUE P/O: _____ SUPPLIER: E.T.M. INDUSTRIES INC. MANUFACTURE AS PER DWG						
Descriptions: C OF C IS REQUIRED						
160 - Identify as per dwg & Stock Location: <u>Lead</u> ***STOCK IN SKIDTUBE CELL***						
170 - QC21- Final Inspection - Work Order Release						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
D3490-5P	Crossbolt Spacer	100 (1 ea)	130-Purchasing	5210481		

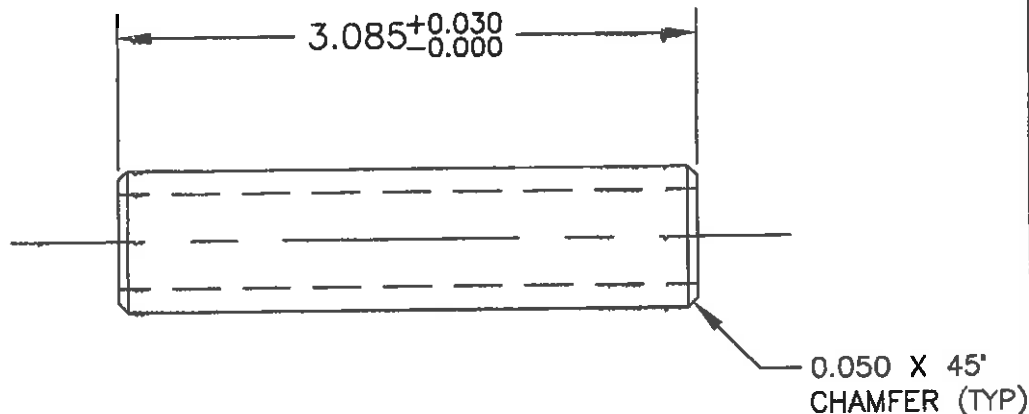
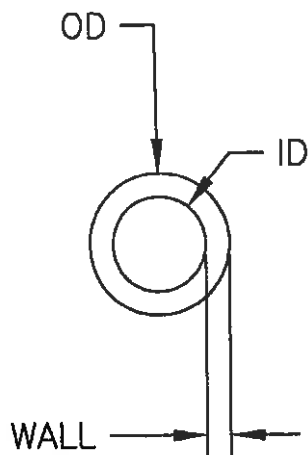
Plex 5/16/19 10:36 AM Dart.Guerin.Kimberley

Job Allocations					
Operation 130-Purchasing	Component Part D3490-5P	Required 100	Inventory 0	Allocated 0	
Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Crossbolt Spacer	3.085inches	+ 0.030 - 0.000	3.115 3.085	
2	Crossbolt Spacer	0.050inches	± 0.010	0.060 0.040	
3	Crossbolt Spacer	45.0Degrees	± 0.0	0.0 0.0	
4	Crossbolt Spacer	0.313inches	+ 0.006 - 0.001	0.319 0.312	
5	Crossbolt Spacer	0.058inches	± 0.010	0.068 0.048	

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DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3490	REV. A SHEET 1 OF 1
DATE 06.01.04		TITLE CROSS BOLT SPACER	SCALE NTS
A	06.01.04	NEW ISSUE	



D3490-1/-3/-5 CROSS BOLT SPACER PARTS LIST

PART NUMBER	OD	WALL	ID (REF)	MATERIAL SPEC
D3490-1	0.500	0.049	0.402	M6061T6T0.500W.049
D3490-3	0.750	0.080	0.591	M6061T6R0.750
D3490-5	0.313	0.058	0.197	M6061T6T0.313W.058

D3490-1/-3/-5 CROSS BOLT SPACER

- 1) MATERIAL: ALUMINUM 6061-T6 (QQ-A-200/8 OR QQ-A-225/8)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
06-02-07

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **POHB043485**



REVISED

Supplier: ETM001-VC
E.T.M. Industries Inc.
310 Hall Avenue, Box 610
Renfrew
ON
K7V 4E7 Canada
Phone: 613-432-6136
Fax: 613-432-8212

PO No: POHB043485
PO Date: 5/16/19
Due Date: 9/6/19
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	195251	D3490-5P			Crossbolt Spacer : as per Dwg D3490-5P RevA	Firmed	-	9/6/19	100 Ea	0 Ea	100 Ea	\$3.45/Ea	\$345.00
												DAS 61 9-89	DP
								AUG 30 2019					
Line Item Note: Material WW-T-700/6 can be use													
2	195252	D4170-1P			Bushing : as per Dwg D4170-1P RevB	Firmed	-	9/6/19	100 Ea	0 Ea	100 Ea	\$4.50/Ea	\$450.00
													DP
								AUG 30 2019					
3	195253	D2971P			Crossbolt Spacer : as per Dwg D2971 RevA1	Firmed	-	9/6/19	50 Ea	0 Ea	50 Ea	\$6.25/Ea	\$312.50
4	195256	D2973P			Crossbolt Spacer : as per Dwg D2973 RevA	Firmed	-	9/6/19	30 Ea	0 Ea	30 Ea	\$18.50/Ea	\$555.00
5	195257	D3504-1P			Crossbolt Spacer : as per Dwg D3504-1 RevC	Firmed	-	9/6/19	100 Ea	0 Ea	100 Ea	\$4.75/Ea	\$475.00



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043485



Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	195258	D3504-3P			Crossbolt Spacer : as per Dwg D3504-3 RevC	Firmed	-	9/6/19	30 Ea	0 Ea	30 Ea	\$12.50/Ea	\$375.00
7	195259	D3662-1P			Crossbolt Spacer : as per Dwg D3662-1 RevA	Firmed	-	9/6/19	100 Ea	0 Ea	100 Ea	\$4.65/Ea	\$465.00
8	195265	D5512-1P			Crossbolt Spacer : as per Dwg D5512-1 RevA	Firmed	-	9/6/19	100 Ea	0 Ea	100 Ea	\$4.00/Ea	\$400.00
9	195264	D3286-3P			Spacer : as per Dwg D3286-3 RevA	Firmed	-	8/23/19	45 Ea	0 Ea	45 Ea	\$11.00/Ea	\$495.00
10	199400	D3286-3P			Spacer : as per Dwg D3286-3 RevA	Firmed	-	9/6/19	5 Ea	0 Ea	5 Ea	\$11.00/Ea	\$55.00

Grand Total: \$3,927.50

Order Notes

Procurement Quality Clauses

A005 RIGHT OF ENTRY
A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 8/22/19 8:54 AM Dart.Guerin.Kimberley

E.T.M. INDUSTRIES INC.
310 HALL AVENUE
BOX 610
RENFREW, ON K7V 4E7
Canada

Ph: 613-432-6136

Fax: 613-432-8212

Pack List

Number: 143917

Date: 27-Aug-19

To

DART AEROSPACE
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
Canada

Ship To

DART AEROSPACE
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-5246

Ph: 613-632-5200

Fax: 613-632-5246

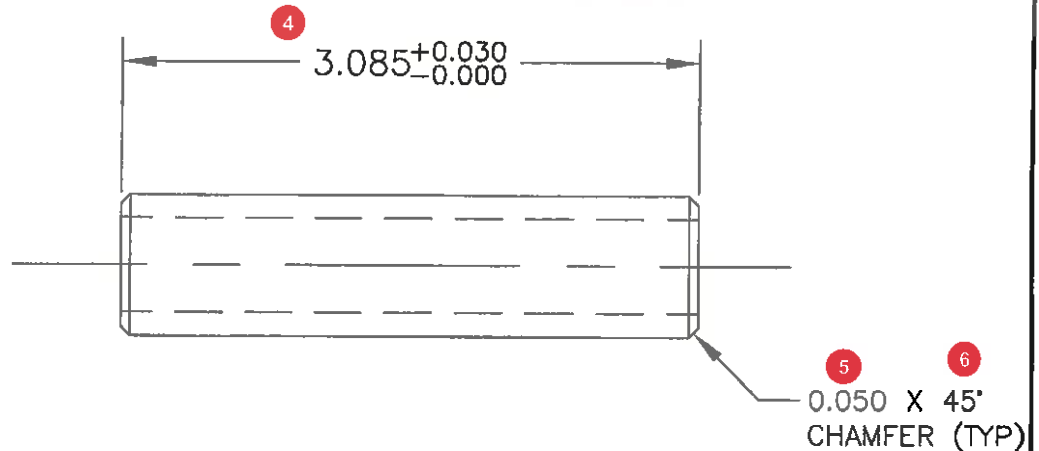
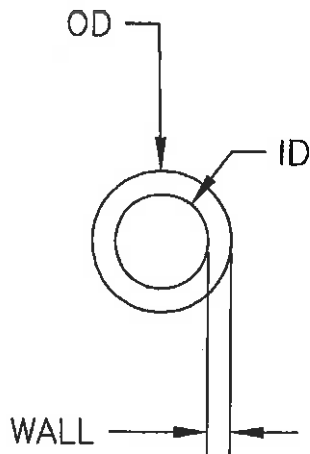
Terms		Ship Via	
Net 30 days			
Quantity	Description	Rev: A	
100 each	Part: D3490-5P CROSSBOLT SPACER SO: 25663 lot 107180	PO: POHB043485 Line: 001	DAS 61 9-89
CERTIFICATE OF COMPLIANCE: "I hereby certify that the material described above is in conformance with applicable physical and dimensional specifications; that it was manufactured in accordance with applicable process specifications; and has been inspected to verify conformance to these specifications." APPROVED SIGNATORY (QUALITY ASSURANCE)			

RECEIVED
AUG 29 2019
DART AEROSPACE LTD.



DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3490	REV. A SHEET 1 OF 1
DATE 06.01.04		TITLE CROSS BOLT SPACER	SCALE NTS
A	06.01.04	NEW ISSUE	

CONTROLLED COPY



D3490-1/-3/-5 CROSS BOLT SPACER PARTS LIST

PART NUMBER	OD	WALL	ID (REF)	MATERIAL SPEC
D3490-1	0.500	0.049	0.402	M6061T6T0.500W.049
D3490-3	0.750	0.080	0.591	M6061T6R0.750
D3490-5	¹ 0.313	² 0.058	³ 0.197	M6061T6T0.313W.058

D3490-1/-3/-5 CROSS BOLT SPACER

- ⁷ MATERIAL: ALUMINUM 6061-T6 (QQ-A-200/8 OR QQ-A-225/8)
- ⁸ ALL DIMENSIONS ARE IN INCHES
- ⁹ TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
06-02-07

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AS9102 Revision B First Article Inspection

Form 1: Part Number Accountability

1. Part Number D3490-5P	2. Part Name CROSSBOLT SPACER	3. Serial Number N/A	4. FAI Number N/A
5. Part Revision Level REV.A	6. Drawing Number D3490-5P	7. Drawing Revision Level REV.A	8. Additional Changes N/A
9. Manufacturing Process Reference 107180	10. Organization Name ETM Industries Inc.	11. Supplier Code N/A	12. P.O. Number POHBO43485 LN.001
13. Detail FAI ☒	14. Full FAI ☒	Baseline Part Number including Revision Level	
Assembly FAI ☐	Partial FAI ☐		
Reason for Partial FAI: Not Applicable		N/A	
a) If above part number is a detail part only, go to Field 19 b) If above part number is an assembly, go to the "Index" section below.			
INDEX of part numbers or sub assembly numbers required to make the assembly noted above.			
15. Part Number	16. Part Name	17. Part Serial Number	18. FAI Report Number
N/A	N/A	N/A	N/A

1) Signature indicates that all characteristics are accounted for; meet drawing requirements or are properly documented for disposition.	
2) Also indicate if the FAI is complete per Section 5.4: ☒ FAI Complete ☐ FAI Not Complete	
19. Signature BARRY DUPUIS	20. Date 8/26/19
21. Reviewed by	22. Date
23. Customer Approval	24. Date

AS9102 Revision B First Article Inspection

Form 2: Product Accountability – Raw Material, Specifications and Special Process(es),
Functional Testing

1. Part Number D3490-5P	2. Part Name CROSSBOLT SPACER	3. Serial Number N/A			4. FAI Report Number N/A
5. Material or Process – Name	6. Specification Number	7. Code	8. Special Process Supplier Code	9. Customer Approval Verification (Yes/No/N/A)	10. Certificate of Conformance Number
ALUMINUM	6061-T6(QQ-A-200/8 OR QQ-A-225/8)	N/A	N/A	N/A	PRECISION TUBE CO. 287 WISSAHICKON AVE. NORTH WALES PA. LOT # 2927553
11. Functional Test Procedure Number	12. Acceptance report number, if applicable				
Not Applicable	Not Applicable				
13. Comments					
14. Prepared By BARRY DUPUIS			15. Date 8/26/19		

1. Part Number D3490-5P		2. Part Name CROSSBOLT SPACER		3. Serial Number N/A		4. FAI Report N/A	
Characteristic Accountability				Inspection / Test Results			
5. Char. No.	6. Reference Location	7. Characteristic Designator	8. Requirement	9. Results	10. Designated Tooling	11. Non Conformance Number	14. Reference Documents
1	SHT.1	N/A	0.313 DIA. +0.006/-0.001	0.312	MICROMETER	N/A	N/A
2	SHT.1	N/A	0.058 +0.004/-0.001	0.0585	CALIPERS	N/A	N/A
3	SHT.1	N/A	0.197 (REF)	0.1985	CALIPERS	N/A	N/A
4	SHT.1	N/A	3.085 +0.030/-0.000	3.103	HEIGHT GAUGE	N/A	N/A
5	SHT.1	N/A	0.050 +0.004/-0.001	0.050	HEIGHT GAUGE	N/A	N/A
6	SHT.1	N/A	45 DEG.	45 DEG.	OPTICAL COMPARATOR	N/A	N/A
7	SHT.1	N/A	MATERIAL:ALUMINUM 6061-T6(QQ-A-200/8 OR QQ-A-225/8)	ACCEPT	PRECISION TUBE CO. 287 WISSAHICKON AVE. NORTH WALES PA. LOT # 2927553	N/A	N/A
8	SHT.1	N/A	ALL DIMENSIONS ARE IN INCHES	ACCEPT	VERIFY	N/A	N/A
9	SHT.1	N/A	TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED	ACCEPT	VERIFY		

The signature indicates that all characteristics are accounted for; meet drawing requirements or are properly documented for disposition.

12. Prepared By

BARRY DUPUIS

13. Date

8/26/19



PRECISION TUBE CO.
287 WISSAHICKON AVE.
NORTH WALES PA 19454

Control No: 6257

CERTIFIED TEST REPORT

CUSTOMER PURCHASE ORDER NO. M 49380591 LINE 001	CUST. ORD. NO. 475790	PRECISION TUBE P/N 24A031250580005
SOLD: TW METALS TO 175 TUBEWAY FOREST PARK, GA 30298 UNITED STATES	SHIP: TW METALS TO 175 TUBEWAY FOREST PARK, GA 30298 UNITED STATES	

QUANTITY ORD.	DESCRIPTION	QTY. SHIPPED	DATE SHIPPED
3204 FT	METAL - 6061 ALUM TEMPER - T6 SPEC - AMS 4082P ASTM-B-210-12 AMS-TW-T-700/6C LENGTH - 12 FT LGTH TOL +.1250 IN -.0000 IN SHAPE - ROUND FINISH - STRAIGHT EXACT LENGTHS OD .3125 +.0030 -.0030 ID WALL .0580 +.0040 -.0040	3456 FT	12/13/17

MECHANICAL PROPERTIES

SAMPLE #	TENSILE STRENGTH (P.S.I.)	YIELD STRENGTH (P.S.I.)	ELONGATION IN 2 INCHES (%)	ROCKWELL HARDNESS	AVERAGE GRAIN SIZE (MM.)
1	46,376	41,941	12		
2	45,712	40,899	15		

DESTRUCTIVE TESTS

Comments: FAR BAA COMPLIES, DFARS BAA COMPLIES, FAR TAA COMPLIES

NON-DESTRUCTIVE TESTS

EDDY CURRENT: PASS

CHEMICAL COMPOSITION

ALLOY: 6061		HEAT:		TRACEABILITY #: X2927553					
				RAW MATL VENDOR: PTC13607 - KAISER ALUMINUM INVESTMENTS					
	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Al
Min	0.40		0.15		0.80	0.04			Rem.
Max	0.80	0.70	0.40	0.15	1.20	0.35	0.25	0.15	
OTHER ELEMENTS: 0.05 MAX EACH / 0.15 MAX TOTAL									

OTHER ELEMENTS: 0.05 MAX EACH / 0.15 MAX TOTAL

We hereby certify that the material has been manufactured in accordance with the requirements of the applicable specifications and descriptions set forth on Precision Tube's sales acknowledgement. During the manufacturing, testing and inspection, the product did not come into direct contact with mercury or any of its compounds, nor with any mercury containing device which might cause mercury contamination. Test results indicate that the material is compliant with the current revision of the RoHS Directive (2011/65/EU).

DEC 19 2017

49380591
TW METALS

Melted and Manufactured in USA
QMS Registered to ISO 9001: 2008

By: *Jennifer James*
Jennifer James
Quality & Technical Lead

12/13/17

Page: 1 of 1

DART AEROSPACE LTD**QUALITY SYSTEM INSTRUCTION: QSI 018****TITLE: Standard Tolerances****ISSUE: 03****DATE: November 30, 2004****PREPARED BY: David Shepherd****REVIEWED****Linda Lacelle
PRODUCTION MANAGER****David Shepherd
CHIEF ENGINEER****Bill Beckett
DESIGN MANAGER****APPROVED BY:****Susanne Sheldon
DIRECTOR, QUALITY ASSURANCE**

Quality System Instruction 018

STANDARD TOLERANCES



Procedure Issue Date: 04.11.30 Issue No: 03

REVISION RECORD: B

PAGE	PAGE REV.	SUBJECT	DATE	INITIAL	DQA
1	A	No change			
2	B	Revised issue page	06.08.03	CH	AS
3	B	Revised Section 4.1	06.08.03	CH	AS

STANDARD TOLERANCES



Procedure Issue Date: 04.11.30

Issue No: 03

1.0 PURPOSE

To establish the tolerances for DART production

2.0 SCOPE

This work instruction applies to all parts manufactured, or designed by DART, unless otherwise stated on a drawing

3.0 RESPONSIBILITY

3.1 PRODUCTION MANAGER

Has the responsibility of ensuring the tolerances are being followed

3.2 DIRECTOR, QUALITY ASSURANCE

Is responsible for auditing that the tolerances are being followed.

4.0 PROCEDURE

4.1 Follow the following requirements (unless otherwise stated):

1. Dimensions are in inches.
2. Surface roughness 125✓. (Visual inspection accepted).
3. Remove sharp edges .015 max.
4. Threads per MIL-S-7742
5. Holes per the following table: (source: AND10387)

Hole Diameter	Tolerance
0.0135 to 0.125	+ 0.004 / – 0.001
0.126 to 0.250	+ 0.005 / – 0.001
0.251 to 0.500	+ 0.006 / – 0.001
0.501 to 0.750	+ 0.008 / – 0.001
0.751 to 1.000	+ 0.010 / – 0.001
1.001 to 2.000	+ 0.012 / – 0.001

6. Dimensions:

X.X	+/- 0.100
X.XX	+/- 0.030
X.XXX	+/- 0.010
7. Angles

	+/- 1/2°
--	----------
8. Parallelism

	+/- 0.0025
--	------------
9. Eccentricity

	0.005 Max
--	-----------
10. Symmetry about all M/C center lines

	0.005
--	-------